

Step 24604

SPLIT

Dart Aerospace Ltd.

Date: Wednesday, 16/04/2008 3:53:38 PM  
User: Julie Lecocq

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 38646		
Estimate Number	: 10437		
P.O. Number	:	Part Number	: D33191
This Issue	: 16/04/2008 S.O. No. :	Drawing Number	: D3319 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B
Previous Run	: 38112	Material	:
	Type : SMALL /MED FAB	Due Date	: 25/04/2008
Written By	:	Qty:	12 Um: Each
Checked & Approved By	: <u>Julie Lecocq</u>		
Comment	: Est: B 05.10.14 Added step 9, dwg rev B KJ/EC Est Rev:C Now on Waterjet 06-10-26 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025/A21/6aA SHEET .048



Comment: Qty.: 0.6594 sf(s)/Unit Total : 7.9128 sf(s)  
1010/1025/A21/6aA SHEET .048  
Batch: 106348 IB 8-4-18

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
1-Cut as per Dwg D3319  
Dwg Rev: B IB 8-4-18  
Prog Rev: B  
2-Deburr if necessary IB 8-4-18



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Done 08/04/18 (12)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr if necessary

Done 8/4/18  
12  
Look at 22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Wednesday, 16/04/2008 3:53:39 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 38646

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

2- Form flat on press using DT8776 block

JB 08/04/21

(12)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

JB 08/04/21 (12)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description Batch

A/R N/A 7560 Hardcoat Rod

M106390

sp 08-04-

(12x)

B38646  
D33191

30min

24/04/2008

S.103 11.41

#1 323.7 F

#2 F

#3 F

#4 F

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

JB 08/04/24 (15)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JB 08/04/24 (15)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

JB 08-04-24 (15)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-L

08/04/24 (5X)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

JB 08/04/24 (5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 16/04/2008 3:53:39 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 38646

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

and Stock

Location: \_\_\_\_\_

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/24 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-24



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

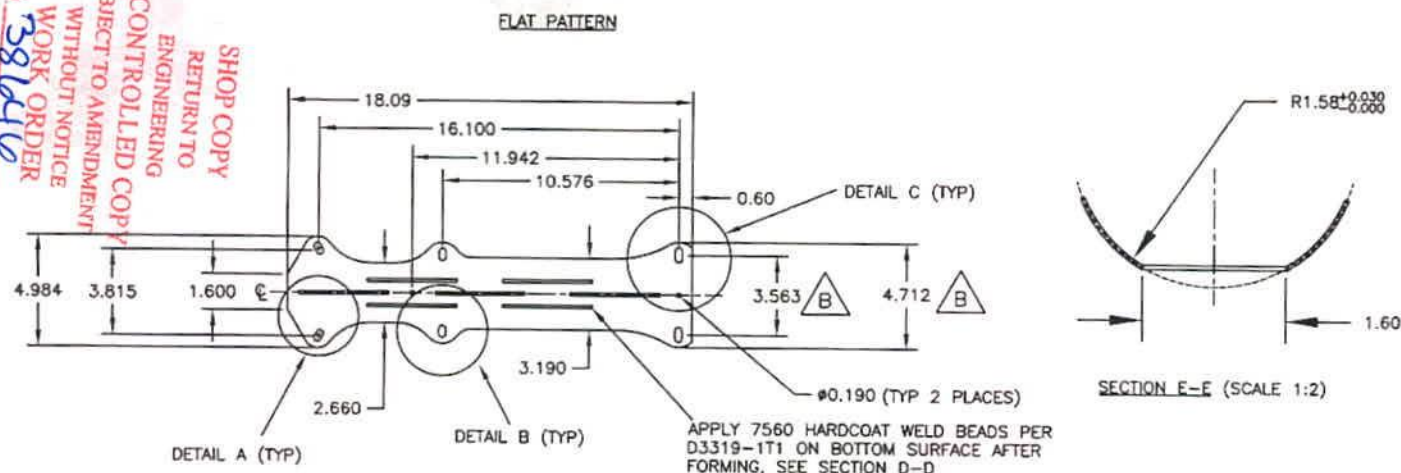
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

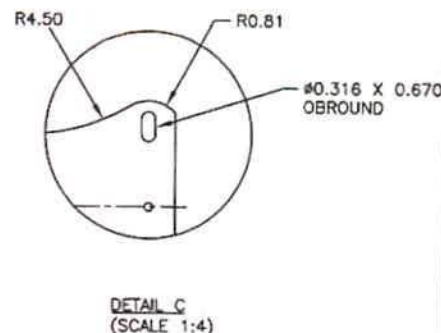
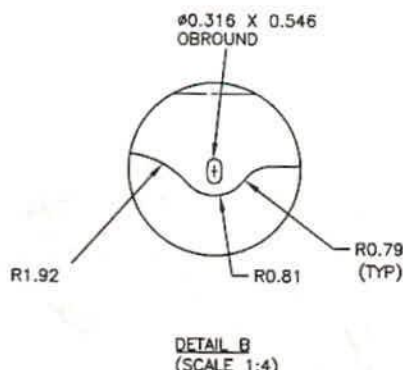
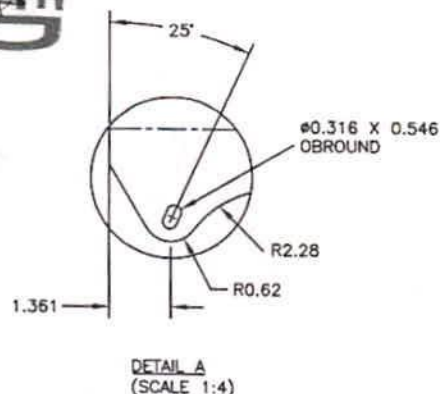
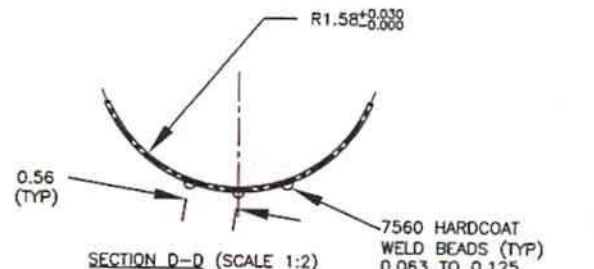
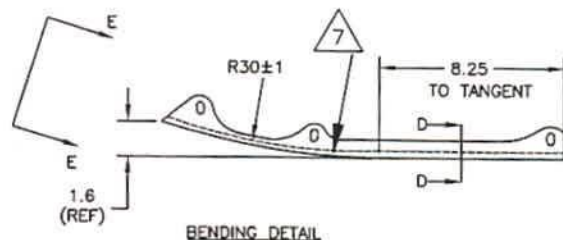


**DART**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38646



**RELEASED**  
05-07-30



DESIGN	DRAWN BY	DART AEROSPACE LTD
P1	P1	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	SCALE
05.06.06	WEARPLATE	1:8
A	NEW ISSUE	REV. B
05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7	SHEET 1 OF 5

**D3319-1 WEARPLATE**

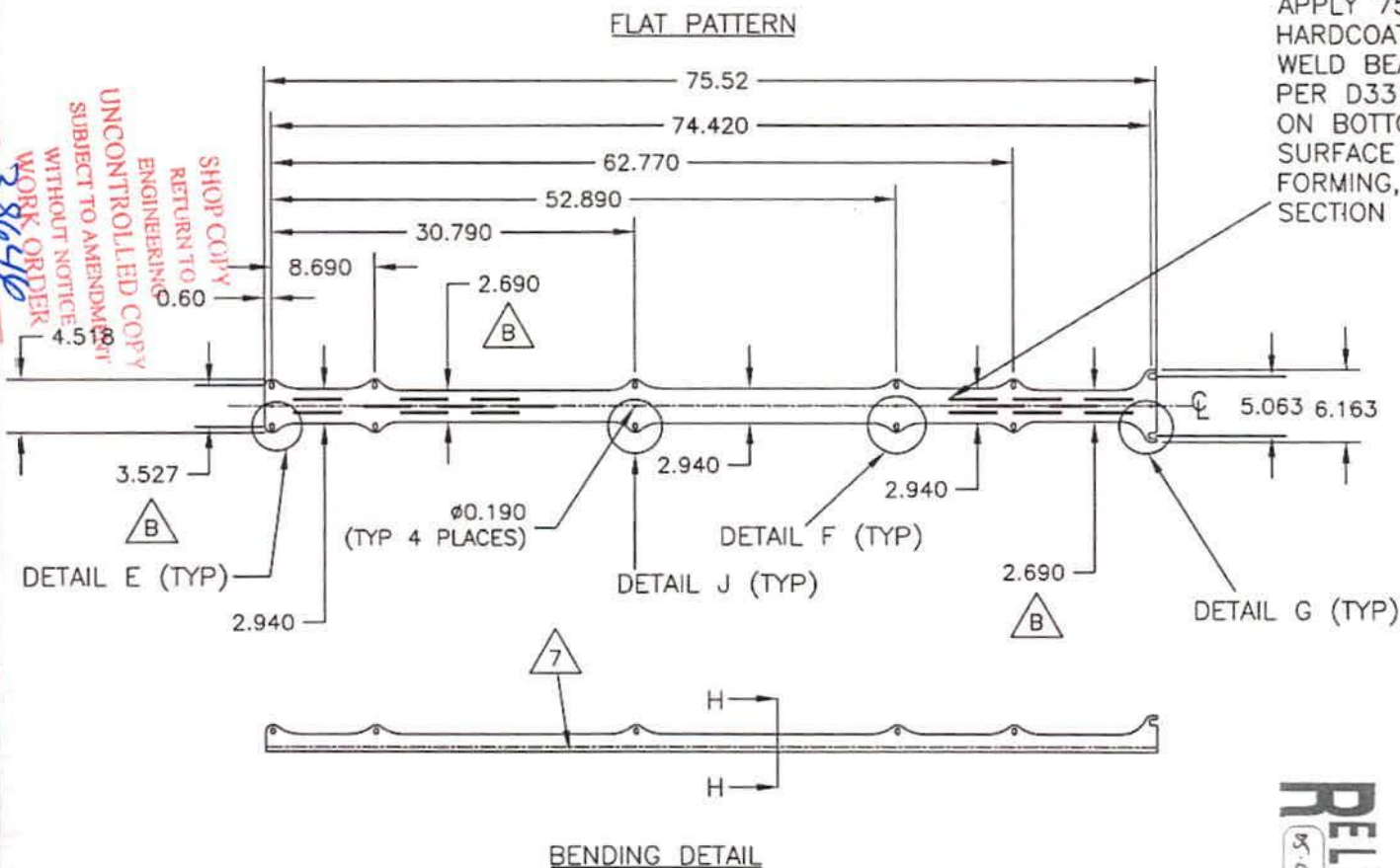
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"



**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>04</i>	APPROVED <i>04</i>	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
05.06.06	D3319	SHEET 2 OF 5
	TITLE	SCALE
	WEARPLATE	1:15

APPLY 7560  
HARDCOAT  
WELD BEADS  
PER D3319-3T1  
ON BOTTOM  
SURFACE AFTER  
FORMING, SEE  
SECTION H-H



#### D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED  
05-01-30

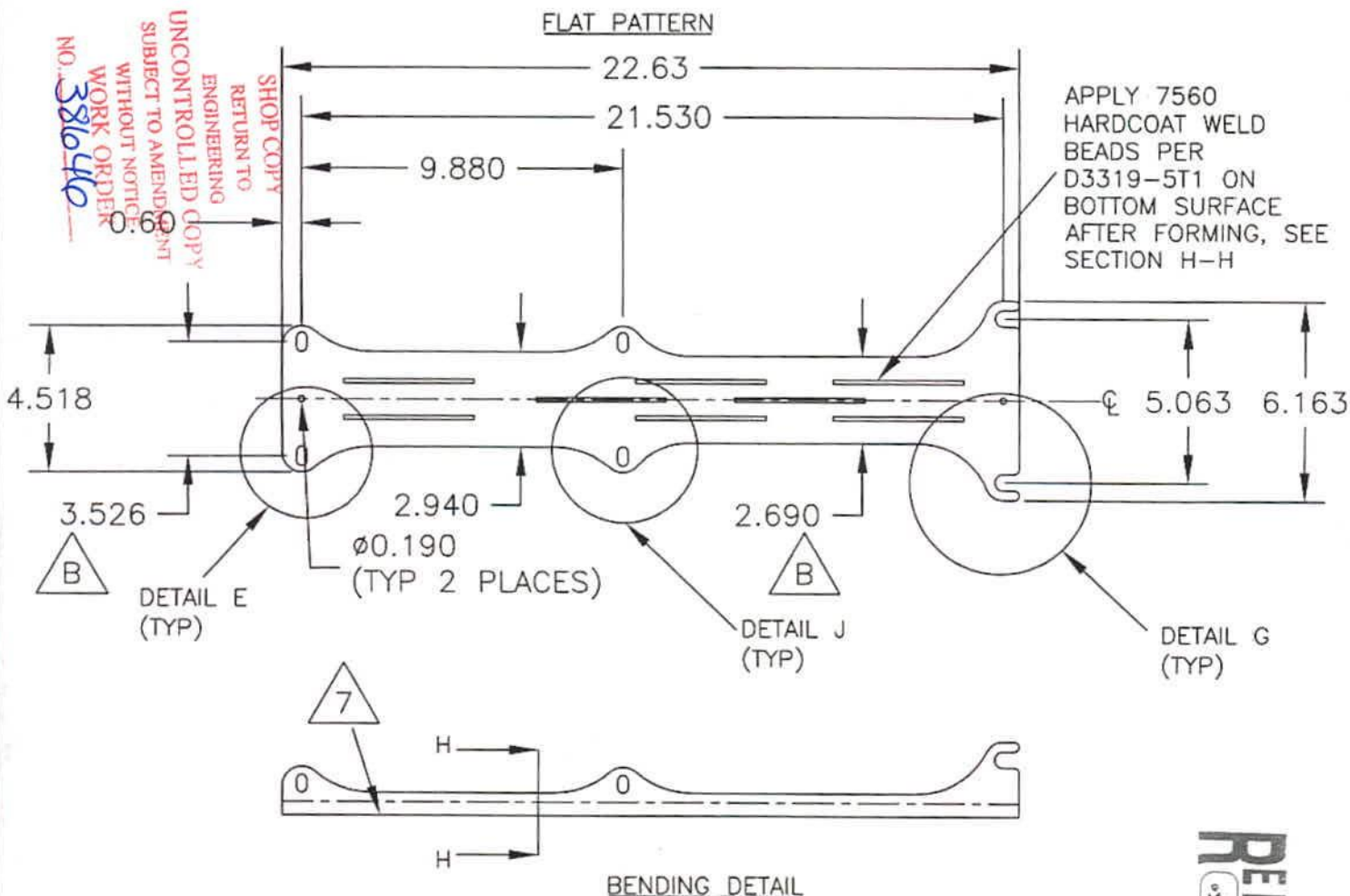
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

NO. 38646  
WORK ORDER  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
SHOP COPY  
RETURN TO  
ENGINEERING

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
041	gt	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D3319
DATE	TITLE	REV. B
05.06.06	WEARPLATE	SHEET 3 OF 5
		SCALE
		1:5



#### D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



DESIGN		DRAWN BY		DART AEROSPACE LTD	
PH		PH		HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. B
				D3319	SHEET 4 OF 5
DATE				TITLE	SCALE
05.06.06				WEARPLATE	1:5



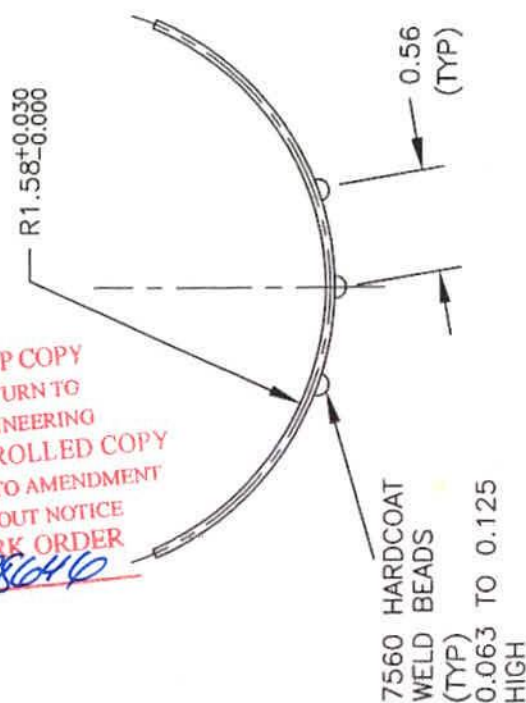
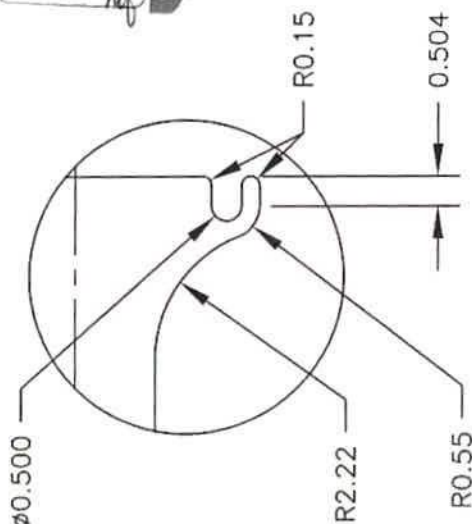
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,  
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**Copyright © 2004 by DART AEROSPACE LTD**

Copyright © 2004 by DART AEROSPACE LTD





SECTION H-H  
(SCALE 1:1)

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.